

Work Order ID 84990

84990

Page 1

Item ID: D2572

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd In 205

Start Date: 30/05/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 08/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/31

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

24 12.7.30

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 84990

Double check by: SL

SL 12-04-31

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension

Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension

Sheets

3-Machine Step No 3 per Folio FA051 and insp

110

0.00

110

CONVENTIONAL MILLING MACHINE

24 12.7.30

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

SL 12-04-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May-31-12 9:13:15 AM

84990

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 30/05/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 08/06/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.00

QC

Memo

Quality Control

130

QC8- Inspect parts - second check

0.00

130

0.00

QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

0.00

HandFinish

Memo

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May-31-12 9:13:15 AM

Item ID: D2572

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd In 205

Start Date: 30/05/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 08/06/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

0.00

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8h00
320°F
8h30

miz1841 ✓

12 & (28) 12/08/07.

160 QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12x ϕ Munoz

170 Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

12x _____ 50
12-8-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84990***84990***

Page 4

May-31-12 9:13:15 AM

Item ID: D2572

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd In 205

Start Date: 30/05/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 08/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/18/12

MWS 12/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 9:13:19 AM

Page 1

Work Order ID: 84990

84990

Parent Item: D2572

D2572

Parent Item Name: Saddle, Fwd In 205

Start Date: 30/05/2012

Required Date: 08/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	25.0000	1	12			

D6101-005

Saddle Billet

**

24 12-7-30

Location	Loc Qty	Loc Code
MAT041	2	
76838	2	
MAT044	23	
79874	19	
81973	4	

87265

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84996
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.005		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.499	.499	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.565	.565	.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.134	.134	.134	.134		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.390	1.390	1.390	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	29
Date:	12-7-30

Audited by:	h.e
Date:	12/08/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	24990
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	24	18	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.000		
F	0.490	0.510		.500	.500	.501	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.501	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.250	.250		
S	0.115	0.135		.126	.126	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.238	.238		
W	0.115	0.135		.124	.130	.130	.131		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.388	1.388	1.388	1.388		
AF	0.115	0.135		.138	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.249	.249	.247		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	12-07-31

Audited by:	B.A
Date:	12/08/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4725

DART AEROSPACE LTD		Work Order:	<i>24990</i>
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				<i>A9</i>	<i>A10</i>	<i>A11</i>	<i>A12</i>		
A	0.438	0.443		<i>.438</i>	<i>.438</i>	<i>.438</i>	<i>.438</i>		
B	1.745	1.755		<i>1.750</i>	<i>1.750</i>	<i>1.750</i>	<i>1.750</i>		
C	3.495	3.505		<i>3.500</i>	<i>3.500</i>	<i>3.500</i>	<i>3.500</i>		
D	1.745	1.755		<i>1.750</i>	<i>1.750</i>	<i>1.750</i>	<i>1.750</i>		
E	7.990	8.010		<i>8.001</i>	<i>7.996</i>	<i>7.994</i>	<i>7.998</i>		
F	0.490	0.510		<i>.498</i>	<i>.497</i>	<i>.496</i>	<i>.496</i>		
G	0.257	0.262		<i>.258</i>	<i>.258</i>	<i>.258</i>	<i>.258</i>		
H	0.375	0.380		<i>.376</i>	<i>.376</i>	<i>.376</i>	<i>.376</i>		
I	0.490	0.510		<i>.500</i>	<i>.500</i>	<i>.499</i>	<i>.500</i>		
J	1.174	1.184		<i>1.179</i>	<i>1.179</i>	<i>1.179</i>	<i>1.179</i>		
K	0.558	0.578		<i>.567</i>	<i>.567</i>	<i>.566</i>	<i>.568</i>		
L	1.174	1.184		<i>1.179</i>	<i>1.179</i>	<i>1.179</i>	<i>1.179</i>		
M	1.490	1.500		<i>1.495</i>	<i>1.495</i>	<i>1.495</i>	<i>1.495</i>		
N	2.495	2.505		<i>2.500</i>	<i>2.500</i>	<i>2.500</i>	<i>2.500</i>		
O	3.869	3.879		<i>3.874</i>	<i>3.874</i>	<i>3.874</i>	<i>3.874</i>		
P	0.115	0.135		<i>.125</i>	<i>.125</i>	<i>.125</i>	<i>.125</i>		
Q	0.115	0.135		<i>.135</i>	<i>.135</i>	<i>.135</i>	<i>.135</i>		
R	0.240	0.260		<i>.250</i>	<i>.250</i>	<i>.251</i>	<i>.249</i>		
S	0.115	0.135		<i>.125</i>	<i>.125</i>	<i>.124</i>	<i>.126</i>		
T	0.178	0.198		<i>.188</i>	<i>.188</i>	<i>.188</i>	<i>.188</i>		
U	2.940	2.980		<i>2.960</i>	<i>2.960</i>	<i>2.960</i>	<i>2.960</i>		
V	0.230	0.250		<i>.239</i>	<i>.240</i>	<i>.240</i>	<i>.239</i>		
W	0.115	0.135		<i>.129</i>	<i>.126</i>	<i>.125</i>	<i>.125</i>		
X	0.307	0.312		<i>.310</i>	<i>.310</i>	<i>.310</i>	<i>.310</i>		
Y	0.760	0.765		<i>.763</i>	<i>.763</i>	<i>.763</i>	<i>.763</i>		
Z	0.352	0.372		<i>.363</i>	<i>.362</i>	<i>.362</i>	<i>.362</i>		
AA	0.470	0.530		<i>.500</i>	<i>.500</i>	<i>.500</i>	<i>.500</i>		
AB	0.615	0.635		<i>.627</i>	<i>.627</i>	<i>.627</i>	<i>.627</i>		
AC	0.053	0.073		<i>.063</i>	<i>.063</i>	<i>.063</i>	<i>.063</i>		
AD	0.240	0.260		<i>.247</i>	<i>.248</i>	<i>.247</i>	<i>.249</i>		
AE	1.375	1.395		<i>1.389</i>	<i>1.389</i>	<i>1.390</i>	<i>1.389</i>		
AF	0.115	0.135		<i>.135</i>	<i>.135</i>	<i>.135</i>	<i>.135</i>		
AG	0.240	0.280		<i>.260</i>	<i>.260</i>	<i>.260</i>	<i>.260</i>		
AH	0.240	0.260		<i>.249</i>	<i>.248</i>	<i>.249</i>	<i>.247</i>		
AI	2.000	2.020		<i>2.004</i>	<i>2.004</i>	<i>2.005</i>	<i>2.004</i>		
AJ	0.023	0.043		<i>.033</i>	<i>.033</i>	<i>.033</i>	<i>.033</i>		
Accept/Reject									

Measured by:	<i>SL</i>
Date:	<i>12-07-31</i>

Audited by:	<i>B.A.</i>
Date:	<i>12/08/02</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WORK ORDER
NO. 24990 MLJ
12/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries